

Work Order ID 63133

Thursday, October 21, 2010 1:30:40 PM

Page 1

Item ID: D206-642-241

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 10/21/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

0.00

100



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-241

CHG005

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.



10-10-26

M11385/m115778 BE 10-10-26
BE 10-10-26



10-10-28

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Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco
each hole as it is being drilled. Verify angle of holes to accommodate rivet heads

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg
D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to
the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

120



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

8/10/10/28



10-10-28

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open crossbolt holes to Ø0.3125"

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650.
Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

140

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

150

0.00



QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

DP 10-11-4

DP 10-11-4

Calul05

40

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail
(without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

E


DP

10-11-5

P10 =>

W/O: 63133

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Perm. change					
10/1/08	# 170	Remove step #170. This step can be checked at step #190		10.11.26			S 10/11/08

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: ☐ 10-11-8 ☐ Time: ☐ 1pm ☐

Finish Date: ☐ 10-11-9 ☐ Time: ☐ 2pm ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☐ 1116040 ☐

Sikaflex expire date: ☐ 11-9-30

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sisal/11

DP 10-11-8

Pho →

Dart Aerospace Ltd

W/O: 63133		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval .QC.Inspector	
10/10/08	190	perm. change change step to QC6 inspection Please change correct survey 10/11/15				10/11/15	10/11/15	
10/11/15	220	QCS to a QC10. ground weld. perm change		10.11.26		10/11/15	10/11/15	

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

BE 10/11/11

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ Aluminum Rod ☐ MILL385

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐ NONE

3 BE 10/11/15

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

BE 10/11/15

220

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

1

10/11/15

230

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

1

10/11/15

W/O:		WORK ORDER CHANGES					
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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00

=> 10/11/12



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 0

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115291

Memo

0.00

Powder Coating

START TIME: 9:15
OVEN TEMPERATURE: 220°
FINISH TIME: 9:45

1 10/11/12

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 10/11/12

1 0

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Sequence ID/
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Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-664-241

Location: _____

PPP Rev: _____

PP 63151

10/11/20 SP

320

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/11/25 JA

MF
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, October 21, 2010 1:30:44 PM

RESEARCH DESIGN AND METHODS

Required Date: 10/28/2010

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

1

Skidtube, 206 Skidtube

Location

Loc Qty

Loc Code

LG

14

61632

4

62684

10

2



Doubler

Location

Loc Qty

Loc Code

ST050

25

52844

25

1

Abstract

Cap

Location

Loc Qty

Loc Code

FP

62

55352

62

E

00000000000000000000000000000000

Web

B63249

①

DP 10-11-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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8-21-00	2							
8-21-00	2							

NOTE: Date & initial all entries

Picklist Print

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Parent Item Name: Replacement Skidtube

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

479.0000

52

52



Cherry Rivet™

Location

Loc Qty

Loc Code

ST311

479

112314

63

113644

16

113749

200

115698

200

(65) DP 10-11-8

D2649

Manufactured

No

200

Each

199.0000

18

18



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

199

58545

2

60652

4

61496

13

62889

180

B 63359 18 BE 10/11/14

D3286-3

Manufactured

No

200

Each

9.0000

2

2



Spacer

Location

Loc Qty

Loc Code

LG

9

46643

9

2 BE 10/11/15

D2680-041

Manufactured

No

210

Each

25.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST021

25

55366

25

1 BE 10/11/15

Thursday, October 21, 2010 1:30:44 PM

Shop Packet Print

Page 2

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Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

1,880.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1880

111359

5

112314

2

114436

448

114450

71

114859

1354

M110153 (2) BE 10/11/15

CCR264SS3-3

Purchased

No

210

Each

422.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

422

112314

4

113539

44

113973

374

2 BE 10/11/15

D2646

Manufactured

No

270

Each

40.0000

1

1



Aft Cap

Location

Loc Qty

Loc Code

FP-4

35

57332

35

fp5

1

61752

1

FP6

4

52663

4

X1

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Shop Packet Print

Page 3

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Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No

270 Each 622.0000 18 18



Plug



10/11/18

Location

Loc Qty

Loc Code

FP
51530
61751
fpa
53349
57869

252
152
100
370
235
135

V18

AN960JD416 NAS1149D0463J Purchased No

270 Each 24.0000 1 1



Washer



10/11/18

M115622

Location

Loc Qty

Loc Code

ST300
113288

24
24

D2651-3 Manufactured No

270 Each 626.0000 18 18



O-Ring



10/11/18

Location

Loc Qty

Loc Code

FP
46114
61962

626
130
496

V18

MS27039-1-08 Purchased No

270 Each 1,584.000 46 46



Screw



Qty (2)

M110835

X2

10/11/18

Location

Loc Qty

Loc Code

ST291
110835
114718
115108

1584
473
111
1000

M116022

V14

+ Qty (44) MS27039-1-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 63133

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

270

Each

2,969.000

44

44



Insert



HL 10/11/18

Location

Loc Qty

Loc Code

PKG11

920

114723

920

ST282

2010

110511

10

115911

2000

vd4

ST381

39

114654

39

MS27039-4-06

Purchased

No

270

Each

108.0000

1

1



Screw



HL 10/11/18

Location

Loc Qty

Loc Code

ST292

108

109061

14

115460

94

XL

AN960JD10L

NAS1149D0332L

Purchased

No

270

Each

0.0000

46



Washer



1114884 VZ HL 10/11/18

46 Qty (2)

vd4 HL 10/11/18

+ Qty (44) AN960JD10L

* NAS1149C0332R / M115832

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Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.11.18	270	USE Qty(44) M27039C1-08 B/N <u>M116022</u> Qty(44) AN960C10L B/N <u>M115832</u> NAS1149CO332R	xl	10/11/18	✓ ✓	CP 10.11.18 QSI 042		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.11.18	270	IPP calling up non-SS hardware for wearplates	CP 10.11.18 QSI 042	Update IPP with correct pin & qty			CP 10.11.18 QSI 042	

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 63133

Parent Item: D206-642-241




Parent Item Name: Replacement Skidtube

Start Date: 10/21/2010




Required Date: 10/28/2010

Start Qty: 1.00




Required Qty: 1.00

D3537-1 Manufactured No 270 Each 50.0000 4 4
   21 10/11/18
 Wearpad




Location	Loc Qty	Loc Code	
FP	1	B62928	X4
55465	1		
FP017	43		
61986	43		
FP17	6		
57713	3		
60491	3		

D3537-3 Manufactured No 270 Each 6.0000 1 1
   21 10/11/18
 Wearpad

Location	Loc Qty	Loc Code	
FP17	6	B62705	X1
60866	6		

D3535-13 Manufactured No 270 Each 7.0000 1 1
   21 10/11/18
 Wearshoe

Location	Loc Qty	Loc Code	
FP018	7		
62006	7		X1

D3536-13 Manufactured No 270 Each 12.0000 1 1
   21 10/11/18
 Gasket

Location	Loc Qty	Loc Code	
FP11	12		
62007	12		X1

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 21, 2010 1:30:44 PM

Page 7

Work Order ID: 63133

Parent Item: D206-642-241



Parent Item Name: Replacement Skidtube

Start Date: 10/21/2010

Required Date: 10/28/2010



Start Qty: 1.00

Required Qty: 1.00

D3535-21	Manufactured	No	270	Each	6.0000	1	1
							<u>10/21/10</u>
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	6	
<u>55730</u>	6	<u>XL</u>

D3536-21	Manufactured	No	270	Each	11.0000	1	1
							<u>10/21/10</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP11	11	
<u>61684</u>	11	<u>XL</u>

D3535-33	Manufactured	No	270	Each	9.0000	1	1
							<u>10/21/10</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP19	9	
<u>61502</u>	9	<u>XL</u>

D3536-33	Manufactured	No	270	Each	7.0000	1	1
							<u>10/21/10</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	7	
<u>58685</u>	7	<u>XL</u>

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 03133
200-10-21

RELEASED
08.07.23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	B	D2650	SHEET 1 OF 6
APPROVED	40	TITLE	SCALE
DE APPR.	H	206/407 SKIDTUBE ASSEMBLIES	NTS
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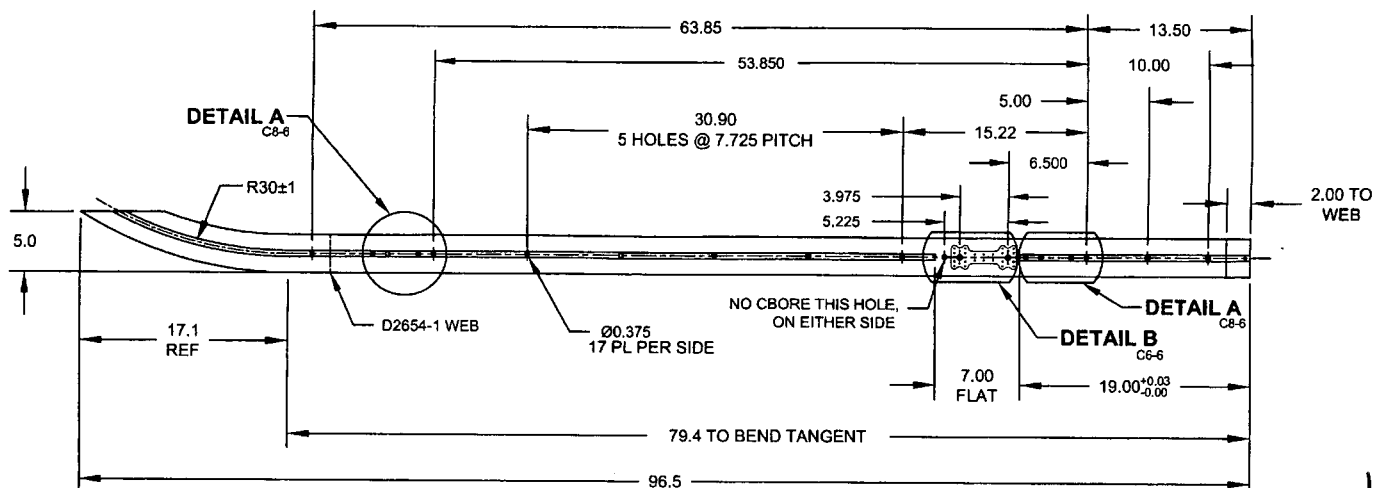
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

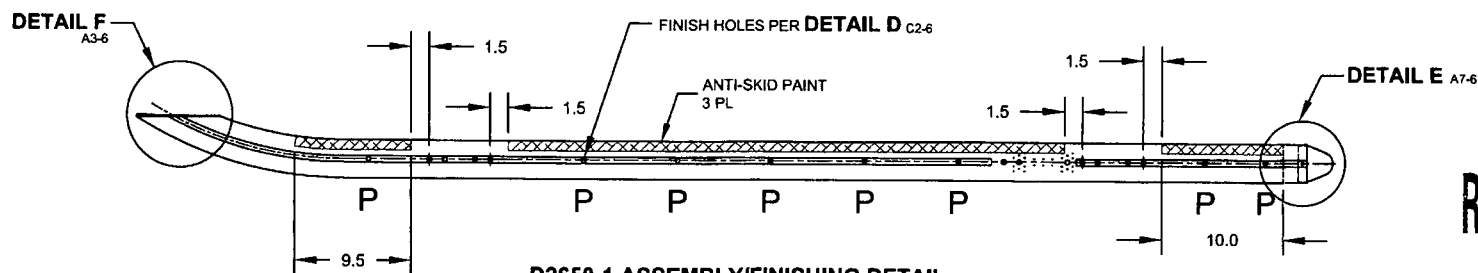
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

WLO 43133

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MFG. APPR.		D2650	SHEET 2 OF 6
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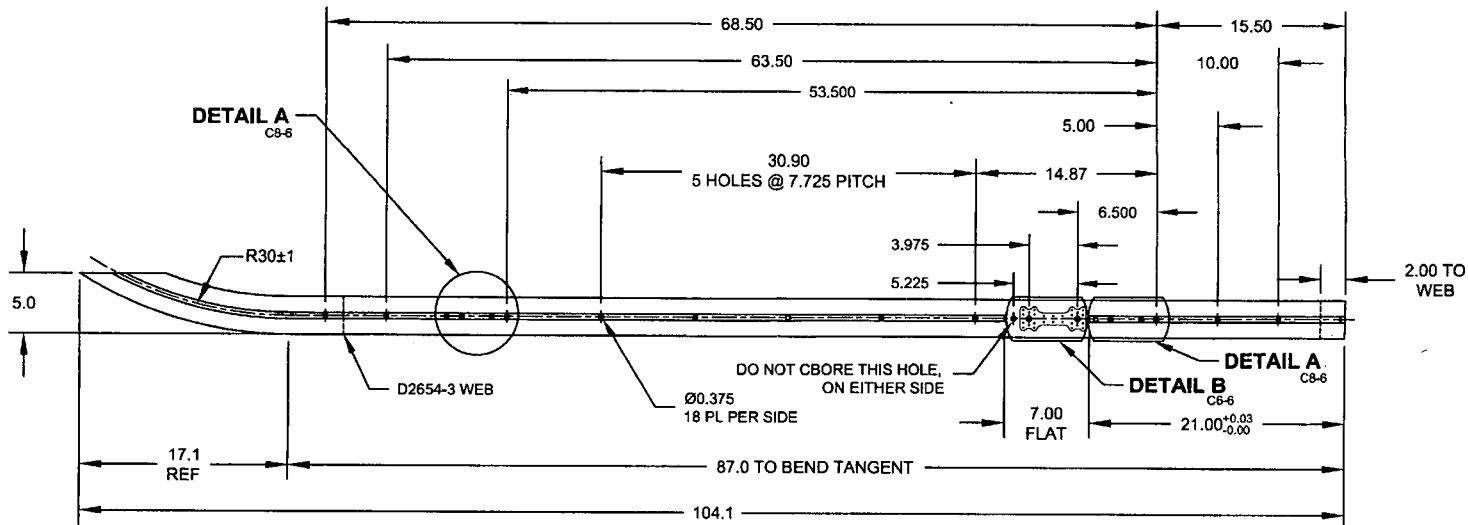
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

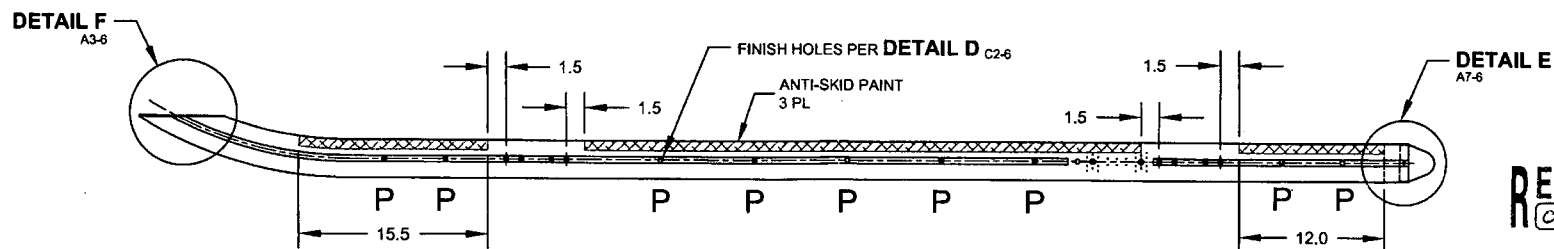
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL

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D2650-3 ASSEMBLY/FINISHING DETAIL

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MFG. APPR.		D2650	SHEET 3 OF 6
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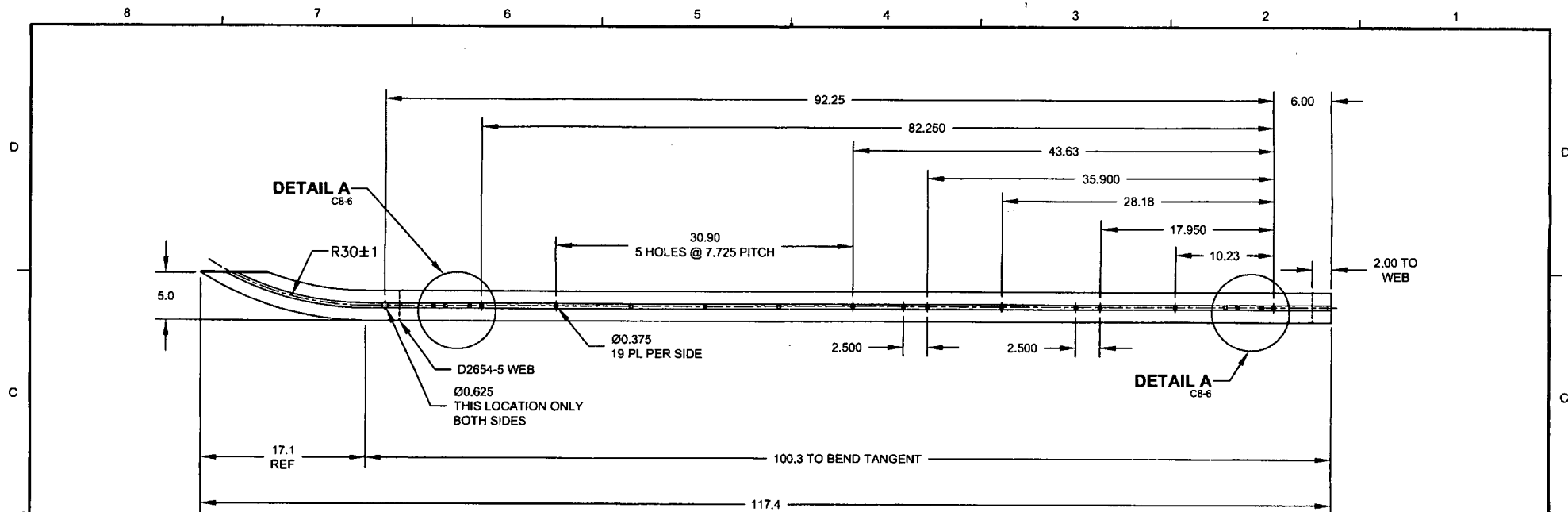
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

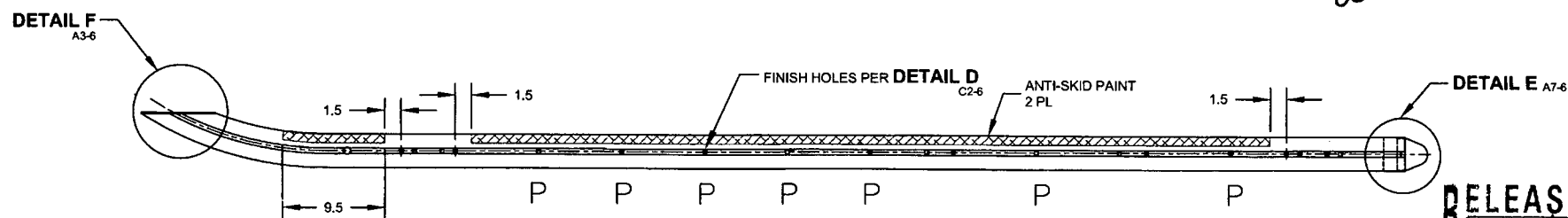
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

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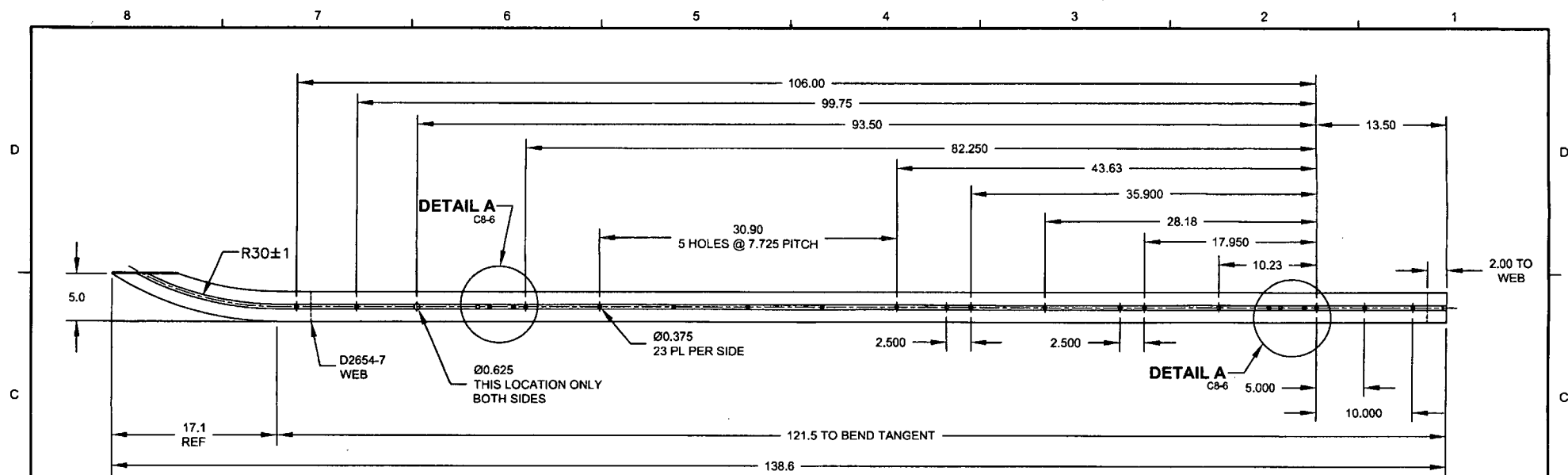
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

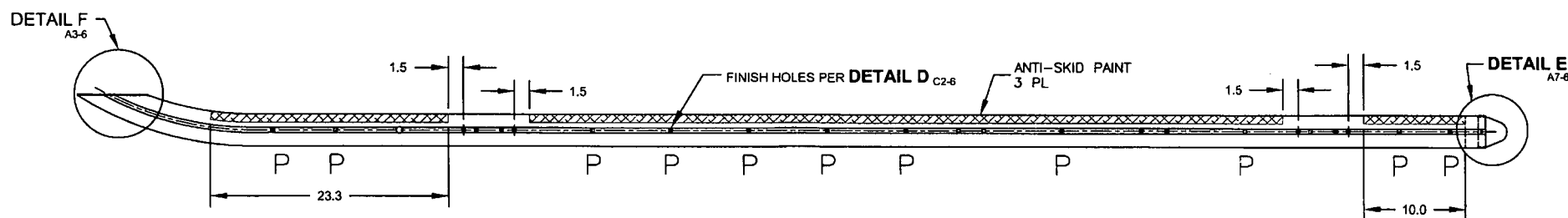
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-7 BENDING/DRILL DETAIL



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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MFG. APPR.	E	D2650	SHEET 5 OF 6
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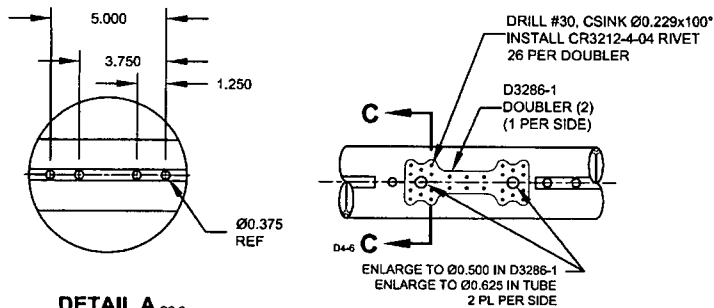
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



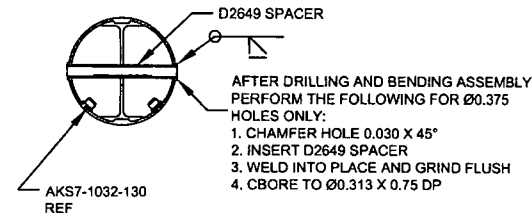
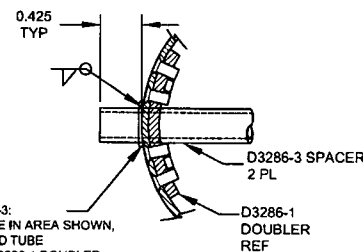
DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5

DETAIL B
SCALE 2X
C3-2
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

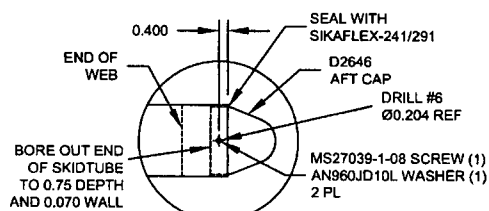


SECTION C-C C7-6
SCALE NONE

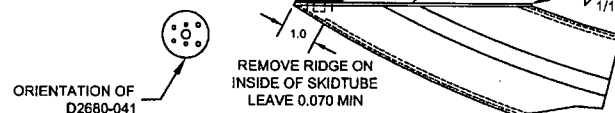


DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

u6-43133



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5







DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-2014

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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